



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3912

Job Sheet 203277



Part No: 646.3912

Job Qty: 40 pcs

Part Name: Shim



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C 1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	40 pcs		12/12/19	0.00	0.91	Waterjet - Flow		OK 20/04/15
120	QC 2	40 pcs		12/12/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 20/04/15
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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130 QC 8	40 pcs	12/12/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 3 - Cadplate	40 pcs	12/12/19		GRO002-VC	10
150 Packaging 2-1 - Receive - B4B	40 pcs	12/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

DA
APR 15 2020 40
8:00

2020-04-15

APR 27 2020

				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		
				Packaging 2 - 31 - B4B		
				Packaging 2 - 32 - B4B		
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
160	QC 6	40 pcs	12/12/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	82
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	QC 6 - 82
						APR 27 2020
170	Packaging 3-1 - Stock - B4B	40 pcs	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS
					Packaging 3 - 8 - B4B	23
					Packaging 3 - 9 - B4B	9-89
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

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				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	40 pcs	12/12/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS

21

9-89

APR 28 2020

Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O: 46280 Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MC1095S.020	C1095 Blue Tempered Spring Steel Sheet .020	.8000 sf (.02 ea)	110-Waterjet - Flow - 1	S254044

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MC1095S.020	1	6	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	1.000Inches $\pm$ 0.005	1.005 0.995	1.005	
2	Shim	2.900Inches $\pm$ 0.005	2.905 2.895	2.905	
3	Shim	0.020Inches $\pm$ 0.005	0.025 0.015	.020	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Engineering ☐ Machining ☐ Water Jet ☐ Large Fab ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____		QTY Affected: _____ MRB (QS1042)	
Description Work Order Deviation						Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐						FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By						Lead hand / Supervisor					
QC / QA Coordinator						Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046280



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046280

PO Date: 4/15/20

Due Date: 4/23/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-04-20

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206320	646.3910	646.3900 Rev NC1	Shim : Various STC's -Issue P/O -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Material type; C1095 BLUE-TEMPERED SPRING STEEL -Certificate of Conformity is required	Firmed X60	-	4/23/20	60 pcs	0 pcs	60 pcs	\$8.2317/pcs	\$493.90
2	203277	646.3912	646.3900 Rev NC1	Shim : Various STC's (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O: Cat Plating, CAD PLATE PER QQ- P-416, TYPE II, CLASS 2, CL2	Firmed X75	-	4/23/20	25 pcs	0 pcs	25 pcs	\$7.4717/pcs	\$186.79
Grand Total:												\$680.69

Handwritten signature: Guerin



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PURCHASE ORDER

POHB046280



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/20/20 9:01 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

027784 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
21-Apr-2020		Jessie Boisvert			POHB046280			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	646.3910 Rev.NC1	646.3900 4 HOURS OF BAKING BEFORE PLATING AT 375 F CAD YELLOW 500 [CADMIUM YELLOW 500] PLATE PER QQ-P-416 TYPE - 2, CLASS - 2 0.0003 "	CADMIUM CH	60	60	0	0	0
2	646.3912 Rev.	646.3912 GLASS BEAD FIRST CAD YELLOW 500 [CADMIUM YELLOW 500] PLATE PER QQ-P-416 TYPE 2 CLASS 2 BAKE AFTER	CADMIUM CH	25	25	0	0	0
3	BAKING CHARGE Rev.	BAKING CHARGE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	1	1	0	0	0

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82
9-89

DATE RECEIVED
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jessie

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.